

17/09

Date: Tuesday, 9/11/2007 10:58:05 AM  
 User: Chantal Lavoie

## Process Sheet

Customer :	Drawing Name :	STIFFNER
Job Number : 34548	Part Number :	D36432
Estimate Number : 12965	Drawing Number :	D3643 UNDER REVIEW
P.O. Number :	Project Number :	N/A
This Issue : 9/11/2007	Type :	SMALL /MED FAB
Prsht Rev. : NC	Drawing Revision :	U/R
First Issue : //	Material :	
Previous Run :	Due Date :	9/18/2007
Written By :	Qty:	20
Checked & Approved By :	Um:	Each
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC	



## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
	Comment: Qty.: 0.1549 sf(s)/Unit Total : 3.0975 sf(s) 2024-T3 .040 sheet Batch: M10522S HB 07-09-17	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3643 Dwg Rev: A HB 07-09-17 Prog Rev: A	(A)
	2-Deburr if necessary HB 07-09-17	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-17	
4.0	QC8	SECOND CHECK
		 counts
	Comment: SECOND CHECK HB 07-09-17 (420)	
5.0	BRAKE NC	NC BRAKE
		 P10
	Comment: NC BRAKE Form as per Dwg D3643 SB 07-09-18	(20) +5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3643-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 34548		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/12	#	2 parts serve R.C. center sink 100	Initial 07/01/12	Errors and Destroy and Replace. Get mode	07/01/12	G	Initial 07/01/12	Initial 07/01/12
	6.0	Deep Human error		Re-Borel and Recount sink	07/01/12	07/01/12	07/01/12	07/01/12

NOTE: Date & initial all entries

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Customer:

Drawing Name: STIFFNER

Job Number: 34548

Part Number: D36432

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 SMALL FAB 1



00

SMALL & MEDIUM FAB RESOURCE 1

Total  
23  
0  
0  
0

Comment: SMALL & MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3643

mf 07-09-21  
mf 07-09-18

7.0 QC5



INSPECT WORK TO CURRENT STEP



cancel  
23

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



23

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BK

07-09-24

9.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



cancel  
23

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1



PACKAGING RESOURCE #1

ENGINEERING  
APPROVAL  
IE 07.10.15

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker then Stock  
Location: 7/10/15 50

11.0 QC21



FINAL INSPECTION/W/O RELEASE



07.10.14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL  
EFFECTIVE 07.09.11 AUTH JH  
RELEASED JCE DATE 07.10.16

07.10.16

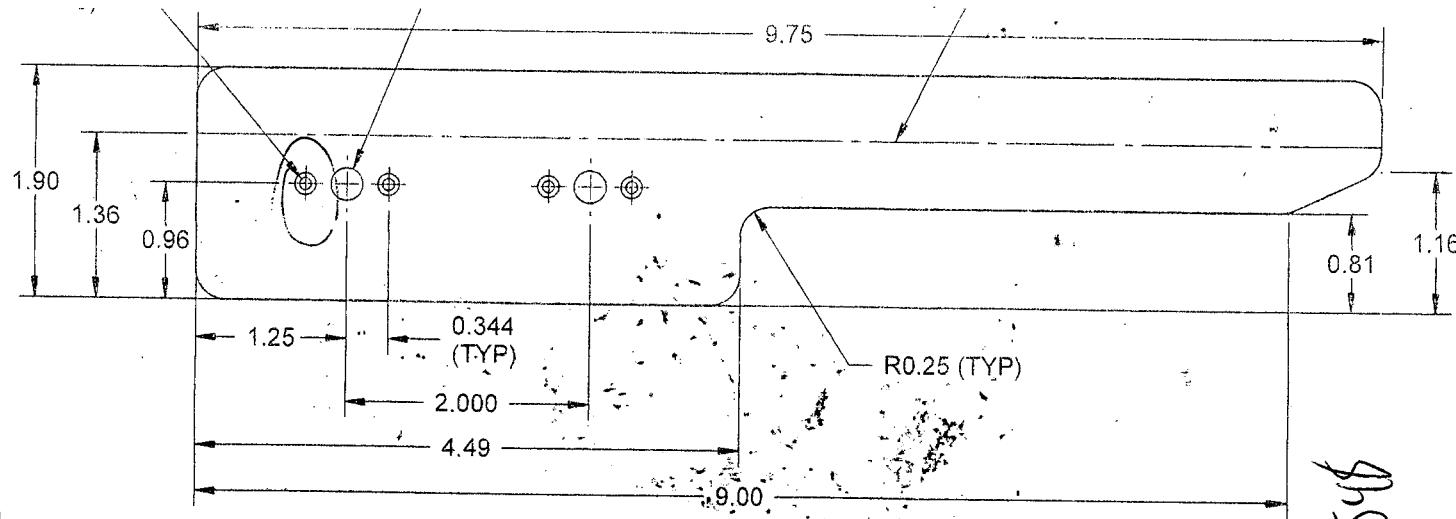
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

GRAIN  
DIRECTION

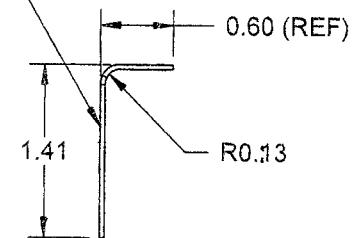
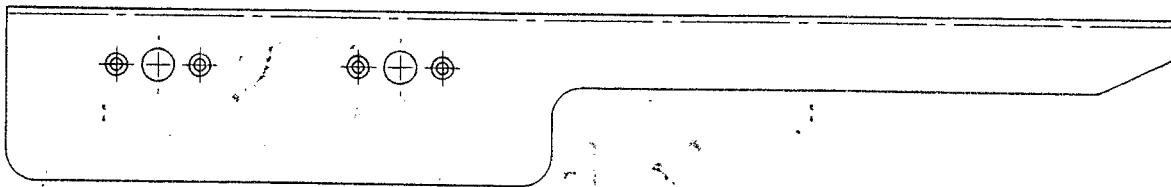


4283334  
MS #18  
MS

D3643-1F FLAT PATTERN  
(D3643-2F OPPOSITE)

W634546

ENSURE THAT COUNTERSINKS  
ARE ON THIS SIDE OF THE PART



D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)  
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)

P131

2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.040  
MICAL CONVERSION COAT PER DART QSI 005 4.1  
S: PER DART QSI-018 UNLESS OTHERWISE NOTED  
1.5 INCHES UNLESS OTHERWISE NOTED

A	NEW ISSUE; REPI
REV.	
DESIGN	DT
DRAWN	CG
CHECKED	
MFG APPROV	12
DATE DRAWN	1/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34548
Description: STI. FINGER	Part Number:	D 3643-2
Inspection Dwg:	Rev: A	Page 1 of 1

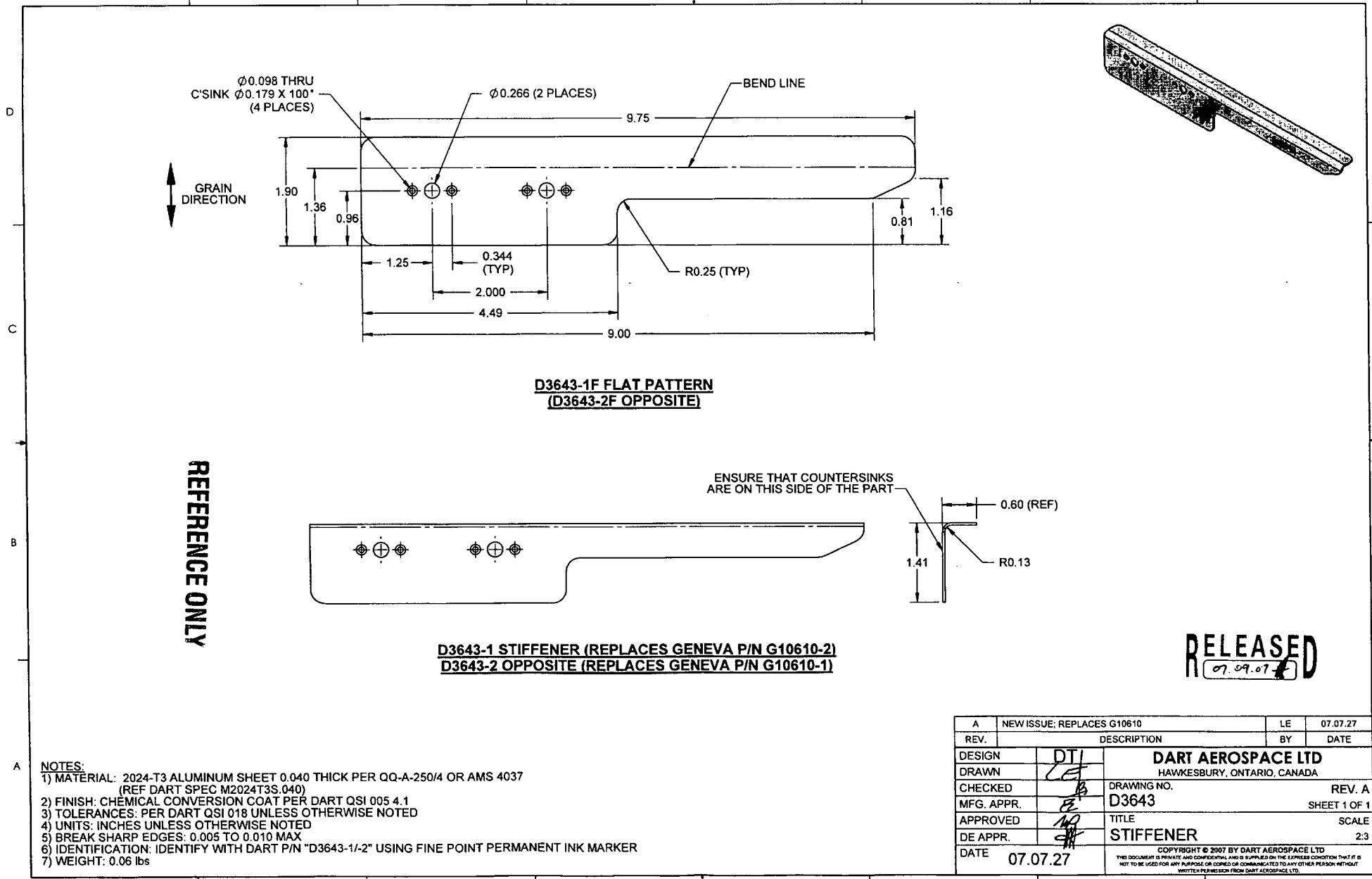
# FIRST ARTICLE INSPECTION CHECKLIST

X First Article      Prototype

Measured by:	iB	Audited by:	Er	Prototype Approval:	W
Date:	07-09-17	Date:	21/09/17	Date:	09/17/07

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1